

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006992**Date Inspected:** 28-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking, and Deviation Saddles**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Art Peterson was present during the times noted above for observations relative to the work being performed in Fabrication shop #4 and the Foundry shop at Japan Steel Works.

Machine Shop #4:

Machining Operation of Saddle: Tower Saddle Segment T1-1 (cast section welded to steel section)

The QA Inspector observed that tower saddle segment T1-1 is located in Machine Shop #4 to have the final machining performed. On this date, the QA Inspector observed that the interior of the south cable trough is being milled to final dimensions on the tower saddle segment.

Fabrication Shop #4:

Grinding Operation of Saddle: Tower Saddle Segment T1-2 (steel section being welded to steel section)

The QA Inspector observed that the JSW personnel were performing the grinding operation around the radius of the cope holes after the partial-joint and complete-joint penetration groove weld operation was completed on one side of the rib plates to base plate and stem plates to base plate of tower saddle segment T1-2. The QA Inspector also observed that the JSW personnel were grinding the welds that were completed on one side of the tee and corner joint welds to an acceptable profile prior to Quality Control (QC) Inspector Mr. Chung Fu Kuan performing a visual inspection in accordance with the approved shop drawings and AWS D1.5-2002 section 3.6 (weld profiles). The QA Inspector observed that the grinding operation around the cope holes and on the tee and corner joint welds were in process at the end of the QA Inspectors' shift.

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NDT Operation pending on Saddle: Tower Saddle Segment T1-3 (cast section welded to steel section)

The QA Inspector observed the partial-joint penetration and the complete-joint penetration butt-joint groove welds on the stem (cast section) to stem plate (steel section) and rib (cast section) to rib plate (steel section) of tower saddle T1-3 were completed. The QA Inspector was informed by Quality Control (QC) Inspector Mr. Chung Fu Kuan that JSW personnel will prepare the tower saddle for the NDT operation prior to performing the post weld stress relief heat treatment operation. On this date, the QA Inspector observed that no work was performed on tower saddle T1-3.

Storage of Saddle: West Deviation Saddle Segment W2-E1 (cast section welded to steel section)

The QA Inspector observed that west deviation saddle segment W2-E1 is located in Fabrication Shop #4. On this date, the QA Inspector observed that no work was performed on west deviation saddle segment W2-E1.

Machine Shop #2:

Machining Operation on Saddle: West Deviation Saddle Segment W2-E2 (cast section welded to steel section)

The QA Inspector observed that west deviation saddle segment W2-E2 is located in Machine Shop #2. On this date, the QA Inspector observed that no machining was performed on west deviation saddle segment W2-E2.

Fabrication Shop #4:

NDT Operation on Saddle: West Deviation Saddle Segment W2-E3 (cast section welded to steel section)

The QA Inspector observed Nikko Inspection Services (NIS) Quality Control (QC) NDT personnel Mr. R. Kumagai (#132) performing the magnetic particle test (MPT) inspection (dry method) on the partial-joint penetration groove welds after the post weld stress relief heat treatment operation on the rib (cast sections) to rib (steel sections) and the stem (cast sections) to stem (steel sections) of west deviation saddle segment W2-E3. The MPT inspection was in accordance with AWS D1.5-2002 Section 6.7.6.2 and to the acceptance criteria outlined in Figure 6.9. The QA Inspector observed that the MPT inspection was in process at the end of the QA Inspectors' shift.

Weld Operation on Saddle: West Deviation Saddle Segment W2-W1 (cast section being welded to steel section)

The QA Inspector observed the partial-joint penetration groove (fill pass) weld operation on the stem (cast section) to stem plate (steel section) of west deviation saddle segment W2-W1. The QA Inspector observed Quality Control (QC) Inspector Mr. Chung Fu Kuan verify prior to and during the weld operation that the minimum preheat temperature of 160 degrees Celsius was maintained and the welding parameters of JSW welding personnel Mr. T. Kawakami (08-5079) on weld joint no. W1S-2U, Mr. M. Kashiwada (08-2008) on weld joint no. W1S-2U, and Mr. Y. Maeyama (92-5234) on weld joint no. W1S-2U were in compliance with WPS SJ-3011-5 per the FCAW process in the (1G) flat position using (1.6) mm diameter TM95 electrode. The QA Inspector observed that the partial-joint penetration groove (fill pass) weld operation was in process at the end of the QA Inspectors' shift.

Cleaning Operation of Saddle: West Deviation Saddle Segment W2-W2 (steel section)

The QA Inspector observed that the post weld (intermediate stress relief) heat treatment operation was completed on west deviation saddle segment W2-W2 (steel section). The JSW personnel moved the west deviation saddle segment to an area for the blast cleaning operation prior to performing the NDT inspection on the partial-joint penetration butt and tee-joint groove welds. The QA Inspector observed that the blast cleaning operation on west deviation saddle segment W2-W2 was in process at the end of the QA Inspectors' shift.

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Storage of Saddle: West Deviation Saddle Segment W2-W2 (cast section)

The QA Inspector observed that west deviation saddle segment W2-W2 (cast section) is located in the Fabrication Shop #4. The JSW personnel completed the dimensional inspection of the rib (cast section) and stem (cast section) of the west deviation saddle segment in Machine Shop #2 to verify the location and dimensions of the ribs and stem against the approved dimensional drawings and assembly control lines. The dimensional inspection was performed prior to the fit-up operation of west deviation saddle segment W2-W2 (steel section). On this date, the QA Inspector observed that no work was performed on west deviation saddle segment W2-W2 (cast section).

Weld Operation on Saddle: West Deviation Saddle Segment W2-W3 (steel section being welded to steel section)

The QA Inspector observed the partial-joint penetration groove (fill pass) weld operation on the rib plate (steel section) to stem plate (steel section) of west deviation saddle segment W2-W3. The QA Inspector observed Quality Control (QC) Inspector Mr. Chung Fu Kuan verify prior to and during the weld operation that the minimum preheat temperature of 160 degrees Celsius was maintained and the welding parameters of JSW welding personnel Mr. T. Ohkawa (03-3091) on weld joint no. W3Y-4V and Mr. D. Kito (08-5175) on weld joint no. W3Y-17V were in compliance with WPS SJ-3011-4 per the FCAW process in the (1G) flat position using (1.6) mm diameter TM95 electrode. The QA Inspector observed that the partial-joint penetration groove (fill pass) weld operation was in process at the end of the QA Inspectors' shift.

Weld Operation of Temporary Fixture to End Splay Cover Plate: East Saddle E2-E1 and E2-W1

The QA Inspector observed JSW welding personnel Mr. Y. Ohta (06-2017) performing the fillet weld operation on the temporary fixture- (reinforcing plates) located between the end splay cover plate stiffeners and fit to the strong backs located under the end splay cover plate per the SMAW process in the (3F) vertical position for east saddle E2-W1 end splay cover plate. The purpose of welding the temporary fixture is to hold the end splay cover plate stiffeners and end splay cover plate into position when the JSW welding personnel start welding the complete-joint penetration tee-joint groove welds of the (4) stiffeners to the end splay cover plate. The Quality Control Inspector Mr. Chung Fu Kuan informed the QA Inspector that JSW uses their in-house weld procedure specification (WPS WE08-CP15 Rev.1) to perform the welding of the temporary fixture- (reinforcing plates) at specific locations to the strong backs located under the end splay cover plate. The QA Inspector observed that the welding of the temporary fixture to east saddle E2-W1 end splay cover plate was in process at the end of the QA Inspectors' shift. On this date, the QA Inspector observed no work was performed on east saddle E2-E1 end splay cover plate. The QA Inspector observed that the welding of the temporary fixture has been completed on east saddle E2-E1 end splay cover plate.

Foundry:

Storage of Saddle: West Deviation Saddle Segment W2-W3 (cast section)

The QA Inspector observed that west deviation saddle segment W2-W3 (cast section) is located in the Foundry Shop for storage until west deviation saddle segment W2-W3 (steel section) is ready for the fit-up operation. On this date, the QA Inspector observed that no work was performed on west deviation saddle segment W2-W3 (cast section).

NDT Operation on Saddle: East Saddle E2-E1 (cast saddle)

The QA Inspector observed NIS QC NDT Personnel Mr. H. Kohama (#86) performing the ultrasonic test (UT) inspection on the rib section and trough section on the exterior of east saddle E2-E1. The UT inspection was

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performed in accordance with ASTM A609M to the acceptance quality levels in Table 2 of ASTM A609M. The UT acceptance quality level (1) is for within (30) mm of the exterior and interior surface for the full length of the trough as shown on the plans and UT acceptance quality level (3) for areas outside of (30) mm of the surface for the full length of the trough and rib sections as shown on the the plans. The areas inspected were marked with (300 x 300) mm grid lines on the exterior of the trough and rib sections for record purposes, identity, and guidance in scanning. The QA Inspector observed that the UT inspection was in process at the end of the QA Inspectors' shift.

Weld Repair Operation pending on Saddle: East Saddle E2-W1 (cast saddle)

The QA Inspector observed that the JSW personnel were in preparation of re-locating east saddle E2-W1 to an area for the start of the repair weld operation on the excavated areas on the exterior of the trough and rib sections. The JSW Representative Mr. Hideaki Kon informed the QA Inspector that JSW are preparing the Major and Minor repair excavation maps and the Major repair excavation map along with the proposed repair procedure will be submitted as an engineering communication sheet (ECS) to American Bridge Fluor (ABF) for approval by the Engineer prior to the start of the Major repair weld operation. The excavated areas were previously inspected by NIS QC NDT Inspector Mr. H. Kohama (#86) by the liquid penetrant test (PT) method and the magnetic particle test (MPT) method to ensure the complete removal of the rejectable indications. The QA Inspector observed that the JSW personnel were still in preparation of re-locating east saddle E2-W1 to an area to start the repair weld operation at the end of the QA Inspectors' shift.

NDT Operation on Rough Machined Surfaces of Saddle: West Jacking Saddle (cast saddle)

The QA Inspector observed NIS QC NDT Personnel Mr. A. Seino (#82) performing the ultrasonic test (UT) inspection on the base plate of the west jacking saddle. The UT inspection was performed in accordance with ASTM A609M to the acceptance quality level (3) in Table 2 of ASTM A609M. The areas inspected were marked with (300 x 300) mm grid lines on the base plate for record purposes, identity, and guidance in scanning. The QA Inspector observed that the UT inspection was in process on the base plate of the west jacking saddle at the end of the QA Inspectors' shift.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Peterson, Art	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
